

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011563**Date Inspected:** 22-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 5CW+5BW temporary attachments (exterior) and OBG Bike Path. The weld designations reviewed are as follows:

5BW+5CW

1. OBW5- 006, 007, 008, 009, 010
2. OBW5A-006, 007, 008, 009, 010
3. BK001-016-007

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

7AE+7BE

Flux Core Arc Welding (FCAW) welding was performed on weld joint 002 located at OBE7B cross beam side of segment. Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joints 002 and 001 located at OBE7B cross beam side of segment. Welder is identified as Mr. Zhang Hanming (220066). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F-1.

BK001-24

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at BK001-024. Welder is identified as Mr. Chen Zhenghua (053742). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2233-Tc-U4b-F-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at BK001-024. Welder is identified as Mr. Xin Meng (053742). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2233-Tc-U4b-F-1.

6AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joints 044 and 048 located at SEG027 cross beam side of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR 1138 repair procedure.

6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located at CA030 cross beam side of segment. Welder is identified as Mr. Wang Zhengbin (216086). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR 1139 repair procedure.

Y Location of repairs areas by above noted welder (216086) is located at 1200mm.

7AE+7BE

Flux Core Arc Welding (FCAW) welding was performed on weld joints 031~035 located at SP461-001 bike path side of segment. Welder is identified as Mr. Lei Weiwen (019006). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F.

Flux Core Arc Welding (FCAW) welding was performed on weld joints 031~035 located at SP449-001 cross beam

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

side of segment. Welder is identified as Mr. Zhen Yi (067949). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
